

BLUE

23

Date: Wednesday, 5/16/2007 8:14:40 AM
 User: Kim Johnston

Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32383 - 1
 Estimate Number : 10939
 P.O. Number : N/A
 This Issue : 5/16/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 30481
 Written By :
 Checked & Approved By :
 Comment : Est: "B" 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev:C As per Rev C 07-03-19 JLM

Part Number : D29382
 Drawing Number : D2938 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 6/6/2007 Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty: 1.0000 Each(s)/Unit Total: 16.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003)	Batch No: B31337 <i>mk 07/06/25</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr	<i>mk 07/06/25</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>mk 07/06/25</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>mk 07/06/25</i>

Date: Wednesday, 5/16/2007 8:14:40 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/0H-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 32383

Part Number: D29382

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.06.26

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005.4.1



②x

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

P104058 c207/06/27 ②



-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0 QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

207-07-03 ②



9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

P 7/1/4 ②



10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



② 07/07/04

Job Completion



U 07.07.04

DART AEROSPACE LTD				Work Order:	32383
Description: 206 Saddle, Outboard, Right side				Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.127	0.126	0.126	0.126		
B	0.100	0.140		0.129	0.129	0.129	0.128		
C	0.100	0.140		0.120	0.120	0.120	0.119		
D	0.210	0.230		0.225	0.223	0.222	0.223		
E	1.245	1.255		1.249	1.250	1.249	1.250		
F	1.245	1.255		1.249	1.249	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.576	1.575	1.575		
J	2.495	2.505		2.498	2.500	2.501	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.240	0.239	0.240		
N	0.100	0.140		0.120	0.119	0.118	0.118		
O	0.540	0.560		0.547	0.547	0.549	0.549		
P	0.490	0.510		0.499	0.501	0.505	0.504		
Q	3.715	3.725		3.719	3.718	3.718	3.716		
R	2.720	2.760		2.744	2.742	2.745	2.743		
S	0.240	0.270		0.254	0.252	0.253	0.252		
T	0.100	0.180		0.135	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.368	1.367	1.366	1.366		
W	0.316	0.321		0.319	0.320	0.320	0.320		
X	1.250	1.270		1.258	1.259	1.258	1.260		
Y	1.565	1.585		1.573	1.570	1.573	1.575		
Z	0.178	0.198		0.183	0.183	0.188	0.183		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>QWL</i>	Audited by:	<i>SD</i>
Date:	07/06/25	Date:	07.06.26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>SD</i>	<i>QWL</i>

DART AEROSPACE LTD	Work Order:	32383
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

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F	1.245	1.255							
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Z	0.178	0.198							
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AH									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>24</i>	<i>gut</i>

DART AEROSPACE LTD		Work Order:	32383
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Inspection Dwg: D2938 Rev. C		Page 1 of 1	

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Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
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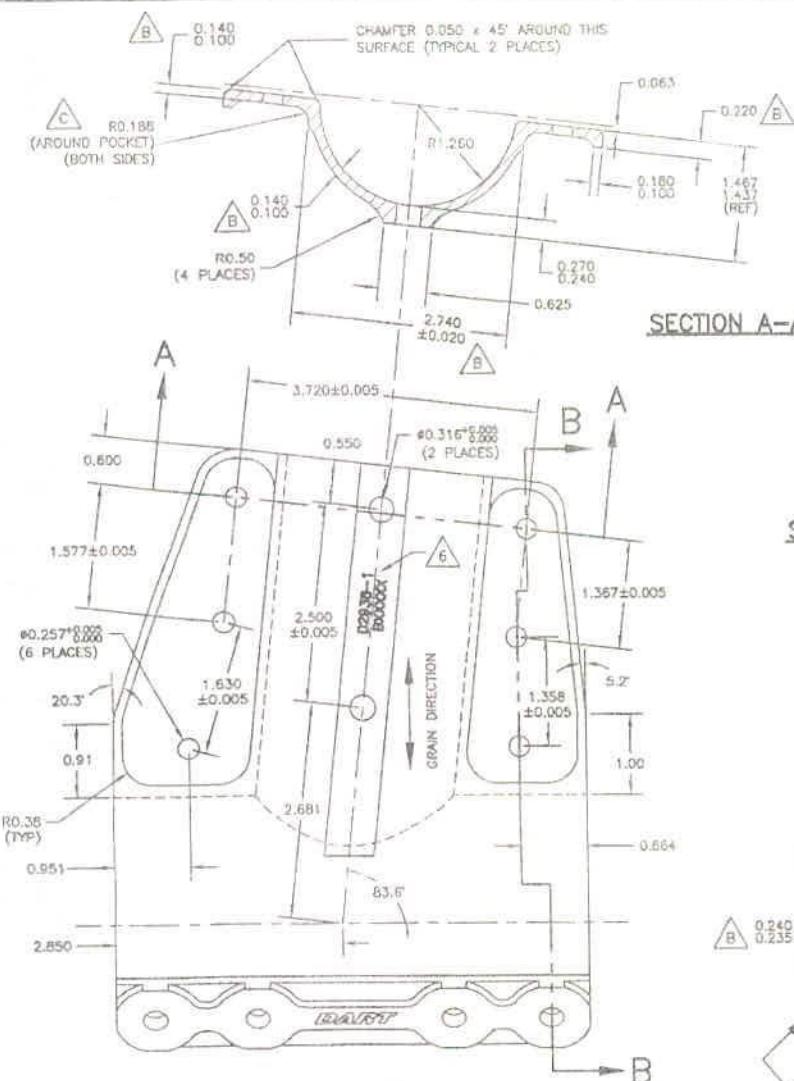
DART AEROSPACE LTD	Work Order:	32383
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

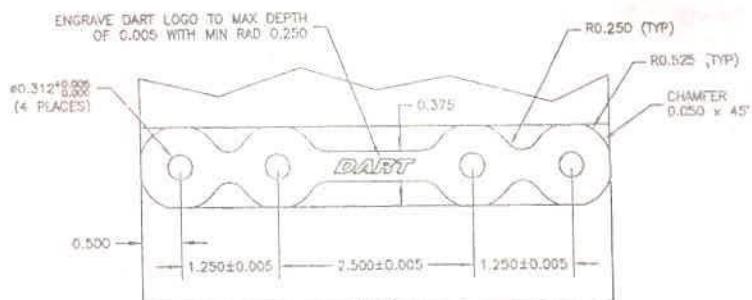
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
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B	0.100	0.140							
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W	0.316	0.321							
X	1.250	1.270							
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AH									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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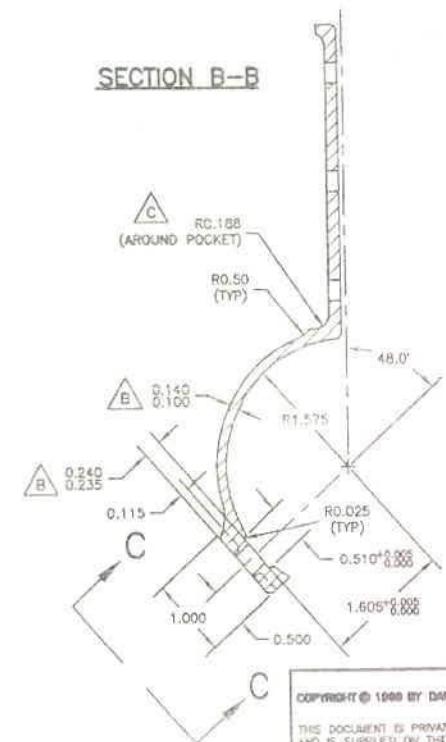


SECTION A-A



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)



NOTES*

NOTES:
1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
MAKE FROM D6101-003 SADDLE BILLET, 7075
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	RD.188 WAS RD.30 TO RD.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN 	DRAWN BY CB	DART DART AEROSPACE USA, INC. BELLMEIR, PA
CHECKED PH	APPROVED 	DRAWING NO. D2938
DATE 06.11.09	TITLE SADDLE OUTSIDE	REV. 1 SHEET 1 OF 2 SCALE 2: